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Tel (613) 632-5200
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D412-630-034
Job Sheet 191043



008532

Part No: D412-630-034

Job Qty: 2 pcs

Part Name: Folding Heli-Access-Step™ RH - Low, High & Float Gear



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 2/20/19

Job Tracking No:

Due Date: 3/29/19

Created By: Jesse White

Type: Stock

Description: SIOP

Note: DWG REV O IPP Rev:A New Issue 06-11-08 JLM IPP rev B ecn1019, added D2807-041 EC verified by:DD
IPP rev :C 11.01.06 added route seq ID DD vef:EC IPP REV:D 13.06.07 PER CHG004 DD vef:JLM IPP REV:E
16.06.23 AS PER IIN REV.O DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Small Fab - 1	2 pcs	3/29/19		0.00	0.90	Small Fab - 1		
							Small Fab - 2		
							Small Fab - 3		DAS
							Small Fab - 4		36
							Small Fab - 5		9-89
							Small Fab - 6		
							Small Fab - 7		
120	QC 5	2 pcs	3/29/19		0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 42		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		DAS
							QC 5 - 68		MAR 14 2019 68
							QC 5 - 9		9-89
							QC 5 - 50		
							QC 5 - 30		
130	Packaging 1-2 - Pick Kit - B4B	2 pcs	3/29/19		0.00	0.00	Packaging 1 - 1 - B4B		
							Packaging 1 - 2 - B4B		
							Packaging 1 - 3 - B4B		
							Packaging 1 - 4 - B4B		MAR 21 2019
							Packaging 1 - 5 - B4B		
							Packaging 1 - 6 - B4B		

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Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					

					Packaging 1 - 7 - B4B	
					Packaging 1 - 8 - B4B	
					Packaging 1 - 9 - B4B	
					Packaging 1 - 10 - B4B	
					Packaging 1 - 11 - B4B	
					Packaging 1 - 12 - B4B	
					Packaging 1 - 13 - B4B	
					Packaging 1 - 14 - B4B	
					Packaging 1 - 15 - B4B	
					Packaging 1 - 16 - B4B	
					Packaging 1 - 17 - B4B	
					Packaging 1 - 18 - B4B	
					Packaging 1 - 19 - B4B	
					Packaging 1 - 20 - B4B	
					Packaging 1 - 21 - B4B	
					Packaging 1 - 22 - B4B	
					Packaging 1 - 23 - B4B	
					Packaging 1 - 24 - B4B	
					Packaging 1 - 25 - B4B	
					Packaging 1 - 26 - B4B	
					Packaging 1 - 27 - B4B	
					Packaging 1 - 28 - B4B	
					Packaging 1 - 29 - B4B	
					Packaging 1 - 30 - B4B	
					Packaging 1 - 31 - B4B	
					Packaging 1 - 32 - B4B	
					Packaging 1 - 33 - B4B	
					Packaging 1 - 34 - B4B	
					Packaging 1 - 35 - B4B	
					Packaging 1 - 36 - B4B	
140 QC 4	2 pcs	3/29/19	0.00 0.00		QC 4 - 26	
					QC 4 - 28	
					QC 4 - 42	
					QC 4 - 58	
					QC 4 - 6	
					QC 4 - 69	
					QC 4 - 9	
					QC 4 - 46	
150 Packaging 3-1 - Stock - B4B	2 pcs	3/29/19	0.00 0.00		Packaging 3 - 1 - B4B	DAS 46 MAR 2 2 2019 9-89
					Packaging 3 - 2 - B4B	DAS 46 MAR 2 2 2019 9-89
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	

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Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					

				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	DAG
155	DC - 1 - B4B	2 pcs	3/29/19	0.00 0.00	DC - 1 - B4B
					21
					9-55
					MAR 22 2019
160	QC 21 - FG	2 pcs	3/29/19	0.00 0.00	QC 21 - FG - 21
					QC 21 - FG - 70
					DAG
					21
					MAR 22 2019

Part Op 110 - Small Fab - Assemble as per dwg D412-630 p.14 *DPS Procy.com M133690*
 Descriptions: 120 - QC5- Inspect part completeness to step on W/O
 130 - pick kit
 140 - QC4- 100% Inspect kits for completeness
 150 - Identify and pack for shipping as per PPP D412-630-034 PPP Rev: _____
 155 - Photocopy bluefile & create labels per PPP D412-630-034 CHG005
 160 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
AN310C8 <i>331</i>	Nut	4 Ea (2 ea)	110-Small Fab - 1	5103998
AN3C21A <i>349</i>	Bolt	2 Ea (1 ea)	110-Small Fab - 1	Fm137680-0
AN8C16 <i>332</i>	Bolt	4 Ea (2 ea)	110-Small Fab - 1	5074164
D2012-107 <i>WA004</i>	Clevis	2 pcs (1 ea)	110-Small Fab - 1	5040916
D2803-042 <i>473</i>	Bracket Assembly	2 pcs (1 ea)	110-Small Fab - 1	5150099
D2804-042 <i>474</i>	RH Step Fwd Bracket	2 pcs (1 ea)	110-Small Fab - 1	1x5150086 1x5150106
D2807-041 <i>011</i>	Prop Assembly	4 pcs (2 ea)	110-Small Fab - 1	5146685
D2813 <i>011</i>	Washer	4 pcs (2 ea)	110-Small Fab - 1	5149998
D3395-1 <i>033</i>	Bushing	8 pcs (4 ea)	110-Small Fab - 1	5041201
D3562-042 <i>PKG</i>	Step Weldment	2 pcs (1 ea)	110-Small Fab - 1	5148931
D3672-15 <i>047</i>	Phenolic Washer	10 pcs (5 ea)	110-Small Fab - 1	5042894
D3672-19 <i>048</i>	Phenolic Washer	8 pcs (4 ea)	110-Small Fab - 1	F148075
D3672-7 <i>047</i>	Washer, Phenolic	8 pcs (4 ea)	110-Small Fab - 1	5131568
MS21043-3 <i>302</i>	Nut	8 Ea (4 ea)	110-Small Fab - 1	5149144
MS24665-302 <i>298</i>	Cotter Pin	4 Ea (2 ea)	110-Small Fab - 1	Fm135672-1
MS24693-C280 <i>297</i>	Screw	4 Ea (2 ea)	110-Small Fab - 1	5137597
MS24693-C285 <i>297</i>	Screw	2 Ea (1 ea)	110-Small Fab - 1	5142073
AN44C7A	Eyebolt	2 Ea (1 ea)	130-Packaging 1-2 - Pick Kit - B4B	5142070
AN4C10A	Bolt	2 Ea (1 ea)	130-Packaging 1-2 - Pick Kit - B4B	5143545
AN4C15A	Bolt	4 Ea (2 ea)	130-Packaging 1-2 - Pick Kit - B4B	5104456
AN4C6A	Bolt	2 Ea (1 ea)	130-Packaging 1-2 - Pick Kit - B4B	5100397
AN5C15A	Bolt	4 Ea (2 ea)	130-Packaging 1-2 - Pick Kit - B4B	5099540
D2806-1	Bushing	4 pcs (2 ea)	130-Packaging 1-2 - Pick Kit - B4B	5158396
D2806-3	Bushing	4 pcs (2 ea)	130-Packaging 1-2 - Pick Kit - B4B	5146101
D2810-5 <i>71</i>	Strut	2 pcs (1 ea)	130-Packaging 1-2 - Pick Kit - B4B	5147482 x1 5145690 x1
D3396-1	Spacer	4 pcs (2 ea)	130-Packaging 1-2 - Pick Kit - B4B	5149111
D3672-17	Phenolic Washer	14 pcs (7 ea)	130-Packaging 1-2 - Pick Kit - B4B	5155286
D3672-5	Washer, Phenolic	14 pcs (7 ea)	130-Packaging 1-2 - Pick Kit - B4B	5153354-25
MS21043-4	Nut	8 Ea (4 ea)	130-Packaging 1-2 - Pick Kit - B4B	5149143
MS21043-5	Nut	6 Ea (3 ea)	130-Packaging 1-2 - Pick Kit - B4B	5099519

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Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
110-Small Fab - 1	AN310C8	4	21	0
	AN3C21A	2	19	0
	AN8C16	4	7	0
	D2012-107	2	12	0
	D2803-042	2	4	0
	D2804-042	2	4	0
	D2807-041	4	36	0
	D2813	4	30	0
	D3395-1	8	30	0
	D3562-042	2	4	0
	D3672-15	10	492	0
	D3672-19	8	156	0
	D3672-7	8	949	0
	MS21043-3	8	1,279	0
	MS24665-302	4	10	0
	MS24693-C280	4	64	0
	MS24693-C285	2	52	0
130-Packaging 1-2 - Pick Kit - B4B	AN44C7A	2	14	0
	AN4C10A	2	31	0
	AN4C15A	4	48	0
	AN4C6A	2	523	0
	AN5C15A	4	54	0
	D2806-1	4	15	0
	D2806-3	4	23	0
	D2810-5	2	16	0
	D3396-1	4	25	0
	D3672-17	14	52	0
	D3672-5	14	514	0
	MS21043-4	8	1,498	0
	MS21043-5	6	107	0
Part Specifications				
Specifications could not be found.				

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Date : _____	Sequence #: _____	QTY Affected : _____		MRB (QSI042)	
Description Work Order Deviation			Disposition		
DART Aerospace Ltd. 1270 Aberdeen Street Hawkesbury, ON K6A 1K7 CANADA TEL: 1 613 632-5200 Email: sales@dartaero.com www.dartaerospace.com Container No: S161551 Part: D412-630-034 Job No: 191043 Serial No/Batch: S161551 Revision: Inspector: Exp Date: Instructions: TC STC SH96-69 Issue 7a FFAH STC SR005951			Completed By		
			Lead hand / Supervisor		
			QC / QA Coordinator		
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ Other _____			Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread ☐		

Qty -033	Qty -034	Qty -243	Qty -244	Part Number	Description
X				D412-630-033	HELI-ACCESS-STEP™ LH (FOLDING)
	X			D412-630-034	HELI-ACCESS-STEP™ RH (FOLDING)
1		X		D412-630-243	STEP ASSEMBLY LH
	1		X	D412-630-244	STEP ASSEMBLY RH
		1	1	D2012-107	CLEVIS
		1		D2803-041	STA 84 BRACKET ASSEMBLY LH
			1	D2803-042	STA 84 BRACKET ASSEMBLY RH
		1		D2804-041	STA 155 BRACKET ASSEMBLY LH
			1	D2804-042	STA 155 BRACKET ASSEMBLY RH
2	2			D2806-1	BUSHING
2	2			D2806-3	BUSHING
		2	2	D2807-041	GAS SPRING ASSEMBLY (WAS D2807)
1	1			D2810-5	STRUT
		2	2	D2813	WASHER
		1		D3562-041	STEP WELDMENT LH
			1	D3562-042	STEP WELDMENT RH
		4	4	D3395-1	BUSHING
2	2			D3396-1	SPACER
7	7			D3672-5	WASHER (OR NAS1515H5)
		4	4	D3672-7	WASHER (OR NAS1515H5L)
		5	5	D3672-15	WASHER (OR NAS1515H3)
7	7			D3672-17	WASHER (OR NAS1515H4)
		4	4	D3672-19	WASHER (OR NAS1515H8)
		1	1	AN3C21A	BOLT
1	1			AN4C6A	BOLT
1	1			AN4C10A	BOLT
2	2			AN4C15A	BOLT
1	1			AN44-C7A	EYEBOLT
2	2			AN5C15A	BOLT
		2	2	AN8C16	BOLT
		2	2	AN310C8	NUT
		2	2	MS24665-302	COTTER PIN (OR AN380C3-4)
		4	4	MS21043-3	NUT
4	4			MS21043-4	NUT
3	3			MS21043-5	NUT
		2	2	MS24693-C280	SCREW (OR MS24694-C65)
		1	1	MS24693-C285	SCREW (OR MS24694-C76)

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